Work Order ID 66680 Page 1 Wednesday, February 23, 2011 3:27:39 PM Item ID: D3201-4 Accept Setup Start **Revision ID:** Stop Item Name: Doubler Start Date: 3/2/2011 **Start Oty: 12.00 Cust Item ID:** Required Date: 3/4/2011 Reg'd Oty: 12.00 **Customer:** Reference: Start Run Date/62-23 Tooling: Process Plan: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Oty Oty Number Stamp Draw Nbr Revision Nhr D3201 Rev B 100 0.00 FLOW WATER JET 86-6-11 SH Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3201 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 BC-6-1181 OC 0.00 Memo Quality Control

QC8- Inspect parts - second check

0.00

Sulvelzo

120

OC

Quality Control

Memo

0.00

Dart Aerospace	e Ltd
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		WC	ORK ORDER CHANG	ES				
STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	PAR #:	Fault Cate	NCR: Yes	No <b>DQ</b>	A:	A: Date:		
R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
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## Work Order ID 66680

Wednesday, February 23, 2011 3:27:39 PM



Page 3

Item ID:

D3201-4

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Doubler

**Start Date:** 3/2/2011

Required Date: 3/4/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Date: Date:

Run

Start Stop



Operation

Description

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ **Work Center ID** 

160

HandFinish Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 

0.00

7m/11/03/02

170

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

180

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Dail Ac	Ospace	Ltu								
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date:		
Resolution:			Dispositi	_ QA: N/C C	losed:		Date: _			
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NC	₹)				
DATE	STEP	Description of NC	1		verification verification				Approval	
	OIL.	Section A	Initial Action Descripti Chief Eng Chief Eng		Sign Date		on C	Approval Chief Eng	QC Inspector	
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## Work Order ID 66680

Wednesday, February 23, 2011 3:27:39 PM



Page 4

Item ID:

D3201-4

Accept



Setup Start



**Revision ID:** 

Item Name:

Doubler

**Start Date:** 3/2/2011 Required Date: 3/4/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/

Work Center ID

QC

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector		
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## **Picklist Print**

Wednesday, February 23, 2011 3:27:46 PM

Work Order ID: 66680

Parent Item:

D3201-4

Parent Item Name: Doubler

**Start Date:** 3/2/2011

Required Date: 3/4/2011

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP Rev: A IPP Rev:B

IPP Rev :C

Removed from 9 Digit

06-01-25

JLM

Now on Waterjet
Added scribing, NCR262

06-08-14 JLM 07.11.29 EC

IPP Rev:D

10.10.29 remove scribe b# & p# DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	62.2847	0.045	0.568421		١.	
										ાહ	6-4-11	E	

2024-T3 .050 sheet

<b>Location</b>	Loc Qty	Loc Code	
MAT22	62.2847		
111381	1-1.89		<u> </u>
113189	0.3947		
114968	50		114968



W/O:	· ·		WC	ORK ORDER CHANG	ES				
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DG	A:	_ Date: _	
	Res	solution:	Dispositio	n:	_ QA: N/C (	Closed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B			ication		Approval
<u> </u>		Section A	Initial Chief Eng	Action Description Chief Eng	tion Sign 8 Date		tion C	Chief Eng	QC Inspector
								1	
					<u> </u>				

DART AEROSPACE LTD	Work Order:	66680
Description: Doubler	Part Number:	D3201-4
Inspection Dwg: D3201 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.76	+/-0.030	3.764	SY		V 1362	
3.46	+/-0.030	3,458	<b>&gt;-</b>		V	
1.68	+/-0.030	1.676	8		v	
0.050	+/-0.010	1057	2		V	
		<u>.</u>				
					-	

Measured by:	B	Audited by:	Preliminary Approval:	
Date:	11-3-39	Date: 10(02/25)	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.11.28	New Issue	KJ/RF A	
В	10.10.27	FAI sheet created for each part for D3201-3/-4	KJ 94	

W/O:			WC	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHA	NGE	В	<b>y</b>	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: \	es N	lo <b>DQ</b>	A:	Date: _	
	R	esolution:	Disposition: QA: N/C Closed:							
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE	0750	Description of NC						Approval	Approval	
DATE	SIEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng			Sign &   Section C		Chief Eng	QC Inspector
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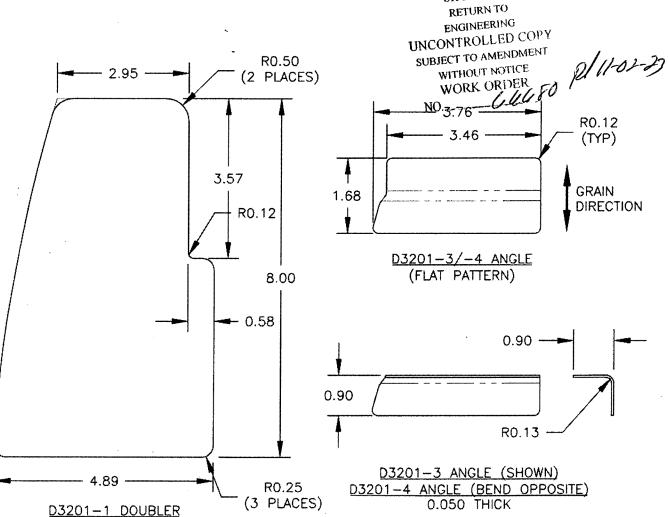


В

	DESIGN		DRAWN BY	ROSPACE LTD IRY, OMTARIO, CANADA	
•	CHEC	KED	APPROVED//	DRAWING NO.	REV. B
		-#-	1	D3201	SHEET 1 OF 1
	DATE	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		TITLE .	SCALE
	03.11.03			DOUBLER	1:2
	Α		03.08.07	NEW ISSUE	
	·				

SHOP COPY

MODIFY D3201-1, ADD D3201-3/-4



03.11.03

#### D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)

(REF. DART SPEC M2024T3S)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

0.040 THICK

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	_ NCR: Yes	CR: Yes No DQA: Date:				
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
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